

SECONDARY PROCESS 200 202 300 Singulation Clean Room Environment Frozen bulk product is dumped and singulated onto conveyor belt 206 204 Freezing Impingement Oven Pasteurized product is Frozen product is passed passed through a freezing through an impingement process (conventional or oven into a clean room cryogenic) to re-freeze the product to <20F. enviroment process to pasteurize the outer surface to a temperature of 170-290 F (ca. 30-60 sec) 208 Weighing & Packing 210 **MAP Packaged** Frozen, pasteurized product is aligined, In-tray product is evacuated weighed, and packed into and flushed with a gas pre-formed plastic trays mixture of oxygen, carbon (ca. 1 lb). dioxide, and nitrogen and lidding stock is applied and/ containers are sealed 212 **Packing** 214 Sealed product is Frozen Storage passed out of the clean room Packaged product is environemnt for held frozen until labeling, casing, and shippment. Figure 2. palletizing.